

Work Order ID 78229

78229

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January-02-12 3:52:19 PM

Item ID: D3574-6 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Cabin Floor Protector
 Start Date: 02/01/2012 Start Qty: 4.00 ***4*** Cust Item ID:
 Required Date: 16/01/2012 Req'd Qty: 4.00 ***4*** Customer:
 Reference:

Approvals: Process Plan: M.L.J Date: 12/01/02 Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D3574	Rev B

100 FLOW WATER JET 0.00
100
 Waterjet Memo 0.00
 FLOW CNC Waterjet 1-Cut as per Dwg D3574 Dwg Rev: B Prog Rev: B 2-
 Deburr if necessary

B12-1-5

(F)

110 QC2- Inspect parts off machine FAI/FAIB 0.00
110
 QC Memo 0.00
 Quality Control

B12-1-5

P10 →

120 QC8- Inspect parts - second check 0.00
120
 QC Memo 0.00
 Quality Control

n 12 01 06 (4)

W/O: 78229		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3574-6 PAR #: _____ Fault Category: Small FAB /
Waste 34 NCR: Yes No DQA: ASZ Date: 23/1/23
 Resolution: Scrap Disposition: Scrap QA: N/C Closed Date: 12/1/23

NCR: 12-112		WORK ORDER NON-CONFORMANCE (NCR) 431.42						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
12/01/13	100	Qty +1 Panel scrap due to too rough of end fin + hole finish from water water jet.	ASZ 12/01/13	Scrap + Destroy + Replac M 119431	12-1-13	ASZ 12/01/13	ASZ 05/04/2	12/01/13
		R.C. LOA. operatn						

NOTE: Date & initial all entries

January-02-12 3:52:19 PM

78229

Page 2

Accept

N900040100

Setup Start *NS1*

Stop *NS2*

Item Name: Cabin Floor Protector

Start Date: 02/01/2012 **Start Qty:** 4.00 ***4***

Cust Item ID:

Required Date: 16/01/2012 **Req'd Qty:** 4.00 *** / ***

Customer:

Reference:

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop *NR2*

**Insp.
Stamp**

0.00

130

Small Fab

0.00

1A 12-01-06

Small Fab

Memo

Small Fab

Deburr if necessary.

140

QC5- Inspect part completeness to step on W/O

0.00

140

Memo

0.00

QC

Quality Control

150

Identify as per dwg & Stock Location:_____

0.00

150

Memo

0.00

Packaging

Packaging

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 78229***78229***

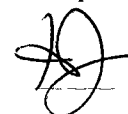
Page 3

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QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	QC21- Final Inspection - Work Order Release	0.00							
160									
QC	Memo	0.00							
Quality Control									

12/1/17 

R12-0417
(4)

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

Picklist Print

January-02-12 3:52:23 PM

Page 1

Work Order ID: 78229

78229

Parent Item: D3574-6

D3574-6

Parent Item Name: Cabin Floor Protector

Start Date: 02/01/2012

Required Date: 16/01/2012

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP Rev :A New Issue 07.07.23 EC verified by:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MLEXS.125-F60029-04		Purchased	No				sf	2,733.665		134.4672			

MI FXS 125-F60029-04

GE PLASTICS LEXAN SHEET

**

1312-1-5

Location

Loc Qty

Loc Code

MAT019

2733.665

115261

77.665

119937

2656

119937

(4)

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	78229
Description: Cabin Floor Protector		Part Number:	D3574-6
Inspection Dwg: D3574	Rev: B	Page 1 of 2	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø3.00	+0.006/-0.001	3.006	X		V BX2	
7.37	+/-0.030	7.37	✓		T (Bul)	
11.00	+/-0.030	11.00	✓		T	
15.25	+/-0.030	15.25	✓		T	
25.87	+/-0.030	25.87	✓		T	
39.75	+/-0.030	39.75	✓		T	
44.75	+/-0.030	44.75	✓		T	
58.38	+/-0.030	58.38	✓		T	
63.50	+/-0.030	63.50	✓		T	
65.25	+/-0.030	65.25	✓		T	
10.25	+/-0.030	10.25	✓		T	
11.87	+/-0.030	11.87	✓		T	
14.75	+/-0.030	14.75	✓		T	
26.00	+/-0.030	26.00	✓		T	
40.87	+/-0.030	40.87	✓		T	
45.00	+/-0.030	45.00	✓		T	
48.00	+/-0.030	48.00	✓		T	
55.13	+/-0.030	55.13	✓		T	
61.25	+/-0.030	61.25	✓		T	
61.88	+/-0.030	61.88	✓		T	
64.63	+/-0.030	64.63	✓		T	
1.13	+/-0.030	1.13	✓		T	
7.63	+/-0.030	7.63	✓		T	
11.00	+/-0.030	11.00	✓		T	
22.10	+/-0.030	22.10	✓		T	
22.50	+/-0.030	22.50	✓		T	
24.50	+/-0.030	24.50	✓		T	
35.13	+/-0.030	35.13	✓		T	
36.50	+/-0.030	36.50	✓		T	
40.00	+/-0.030	40.00	✓		T	
41.88	+/-0.030	41.88	✓		T	
43.63	+/-0.030	43.63	✓		T	
6.75	+/-0.030	6.75	✓		T	
9.50	+/-0.030	9.50	✓		T	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	78229
Description: Cabin Floor Protector		Part Number:	D3574-6
Inspection Dwg: D3574 Rev: B		Page 2 of 2	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
10.38	+/-0.030	10.38	✓		T B61	
14.50	+/-0.030	14.50	✓		T	
16.75	+/-0.030	16.74	✓		T	
18.94	+/-0.030	18.94	✓		T	
19.00	+/-0.030	19.00	✓		T	
24.13	+/-0.030	24.13	✓		T	
33.88	+/-0.030	33.88	✓		T	
39.50	+/-0.030	39.50	✓		T	
40.25	+/-0.030	40.24	✓		T	
43.50	+/-0.030	43.50	✓		T	
46.60	+/-0.030	46.60	✓		T	
0.125	+/-0.010	0.130	✓		V B02	

Measured by: RB	Audited by: M/N	Prototype Approval:	N/A
Date: 15-1-2	Date: 12-01-06	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	08.01.16	New Issue	KJ/DD	
B	09.05.15	Dimensions updated per Dwg Rev B	KJ	

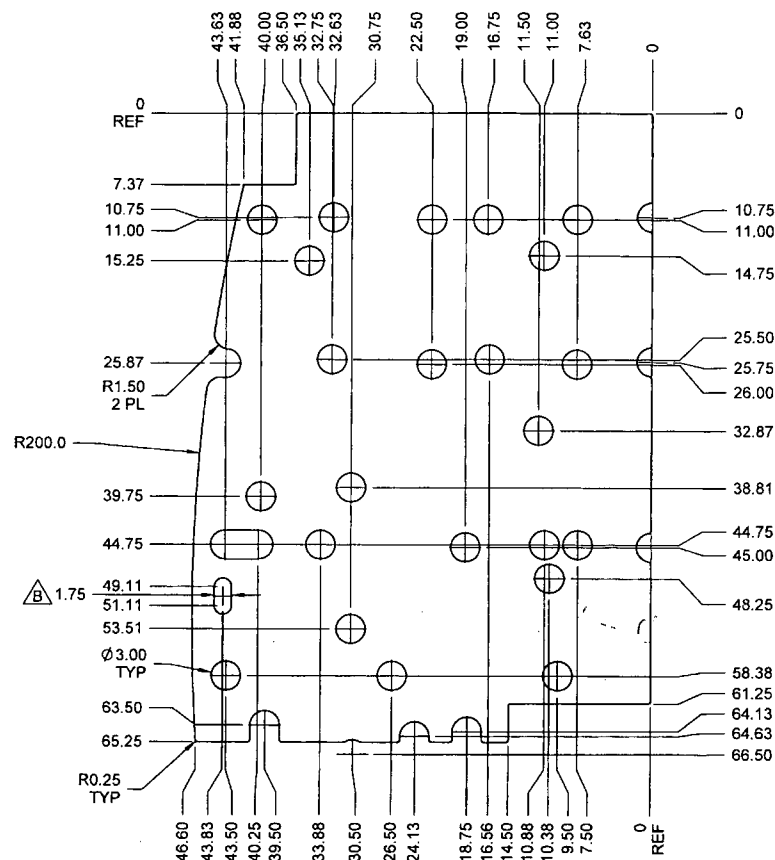
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



D3574-1 CABIN FLOOR PROTECTOR

NOTES:

- 1) MATERIAL: F60029 GREY LEXAN SHEET (HEAVY HAIRCELL TEXTURE), 0.125 THICK, TEXTURED SIDE UP, (REF DART SPEC MLEXS.125-F60029-04)
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3574-1" AND B/N USING FINE POINT PERMANENT INK MARKER ON SMOOTH SIDE OF PART
- 7) WEIGHT: 14.30 lbs
- 8) CHECK PER TEMPLATE DT8961

NOT TO SCALE
FOR INFORMATION
UNCONTROLLED COPY
SUBJECT TO CHANGE
WITHOUT NOTICE
WORK IN PROGRESS
NO. 78229 M.L.J
12/01/02

RELEASED
09/04/07

B	ADD CUT-OUT TO -1/4" FOR WEIGHT AND BALANCE DATA PLATE ZN 87-1, 88-5; -2 NOW SHOWN ON SHEET 2	09.03.25
A	NEW ISSUE	CB 07.06.08
REV.	DESCRIPTION	BY DATE
DESIGN		
DRAWN		
CHECKED		
MFG. APPR.		
APPROVED		
DE APPR.		
DATE	09.03.25	

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. D3574
REV. B
SHEET 1 OF 6
TITLE CABIN FLOOR PROTECTOR
SCALE NTS

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

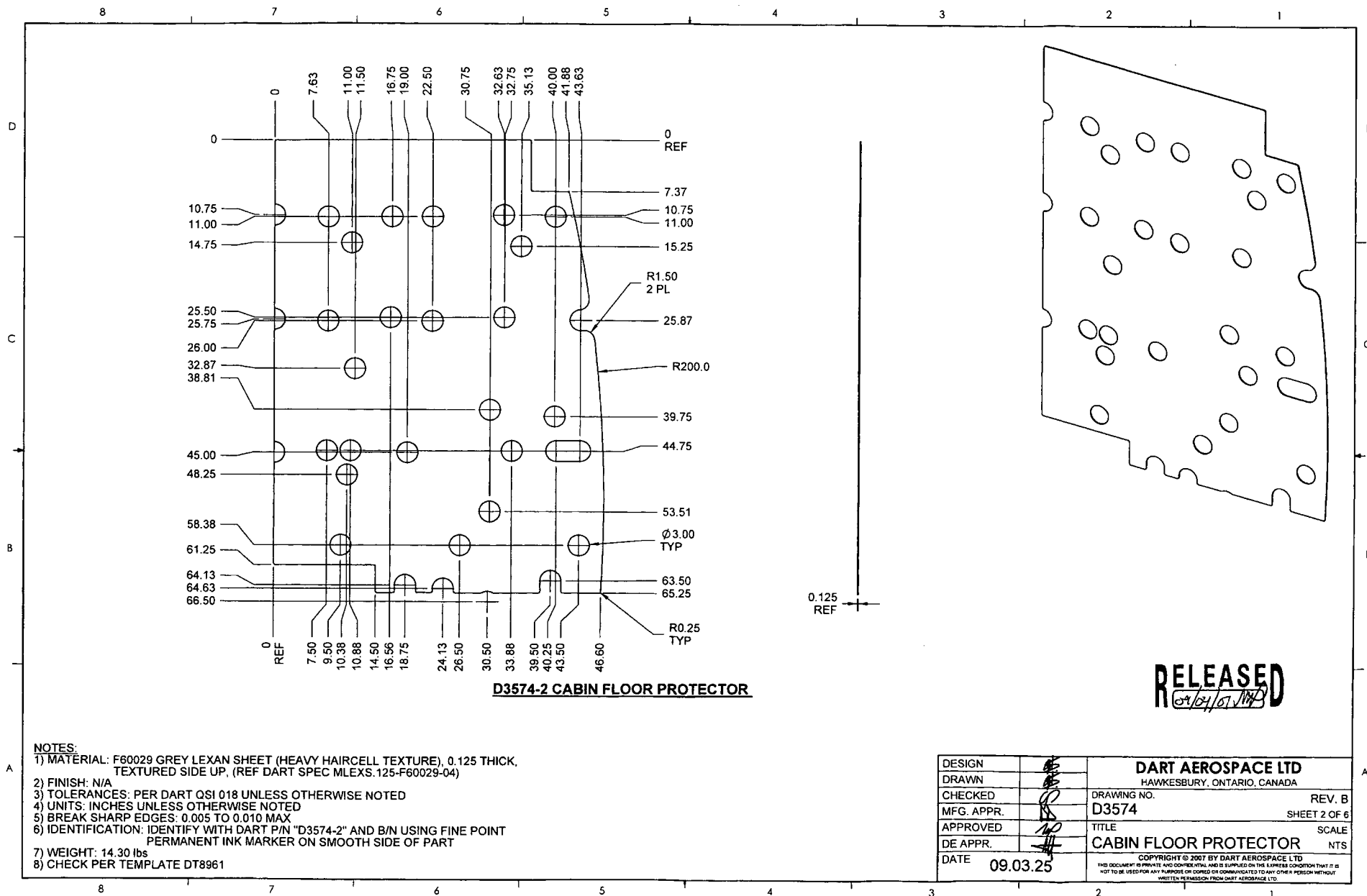
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

78229



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

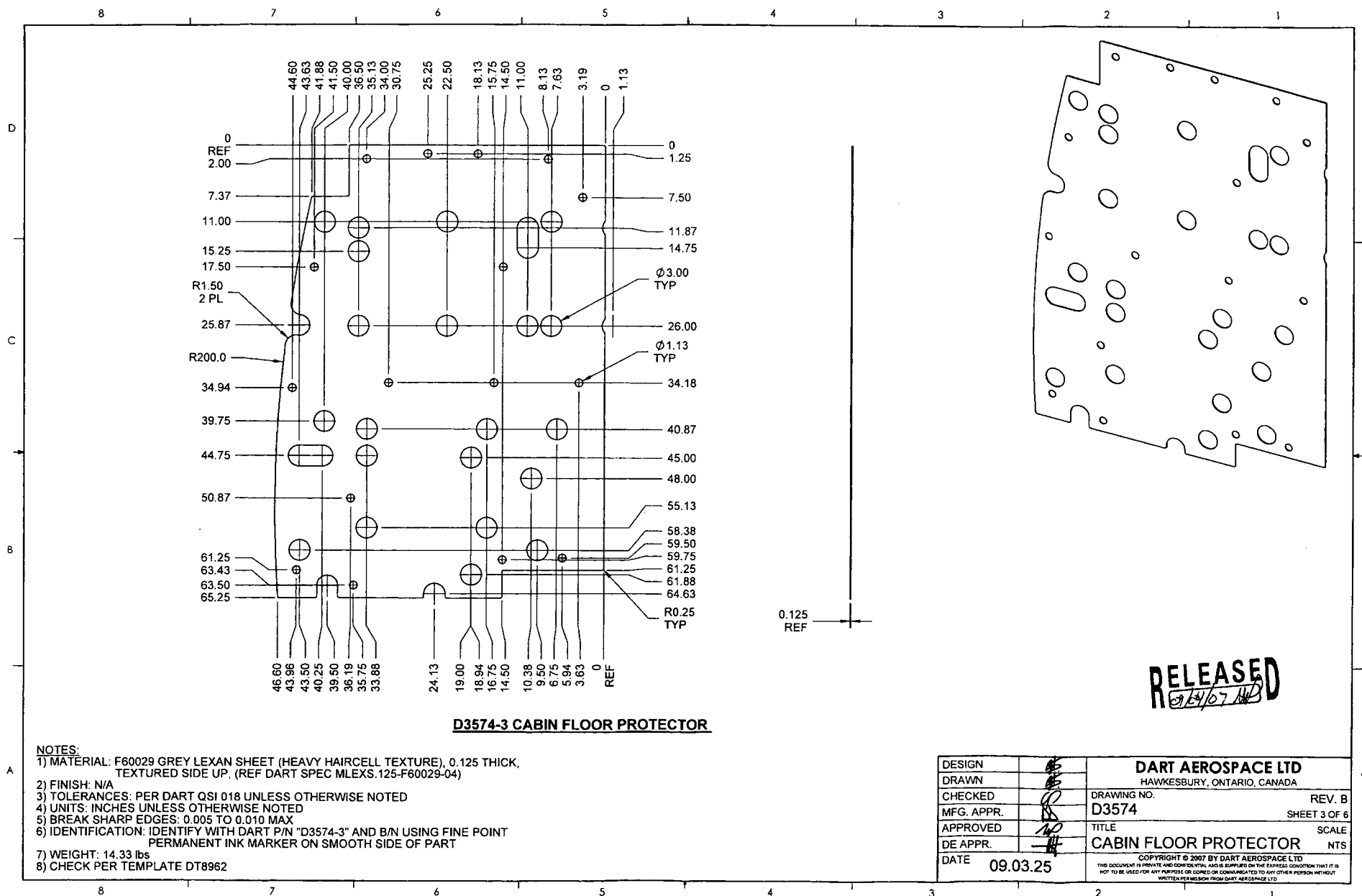
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

78229



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

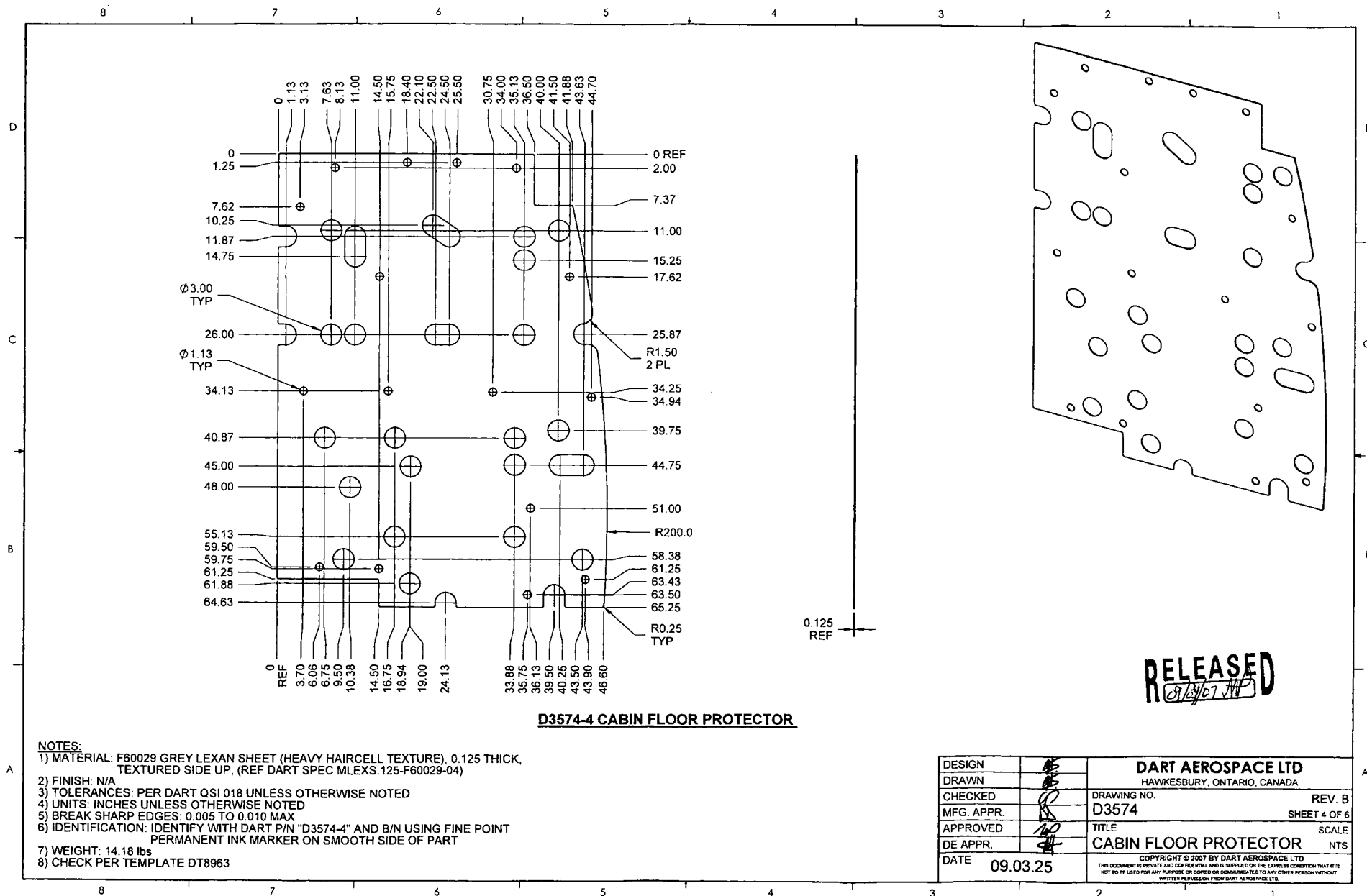
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

78229



D3574-4 CABIN FLOOR PROTECTOR

RELEASED
09/03/25

NOTES:

- 1) MATERIAL: F60029 GREY LEXAN SHEET (HEAVY HAIRCELL TEXTURE), 0.125 THICK, TEXTURED SIDE UP, (REF DART SPEC MLEXS.125-F60029-04)
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3574-4" AND B/N USING FINE POINT PERMANENT INK MARKER ON SMOOTH SIDE OF PART
- 7) WEIGHT: 14.18 lbs
- 8) CHECK PER TEMPLATE DT8963

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D3574	SHEET 4 OF 6
APPROVED		TITLE	SCALE
DE APPR.		CABIN FLOOR PROTECTOR	NTS
DATE	09.03.25	<small>COPYRIGHT © 2007 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

8 7 6 5 4 3 2



RELEASED
9/04/07

1) MATERIAL: F60029 GREY LEXAN SHEET (HEAVY HAIRCELL TEXTURE), 0.125 THICK, TEXTURED SIDE UP, (REF DART SPEC MLEXS.125-F60029-04)

- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3574-S" AND B/N USING FINE POINT PERMANENT INK MARKER ON SMOOTH SIDE OF PART
- 7) WEIGHT: 14.38 lbs
- 8) CHECK PER TEMPLATE DT8964

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D3574	SHEET 5 OF 6
APPROVED		TITLE	SCALE
DE APPR.		CABIN FLOOR PROTECTOR	NTS
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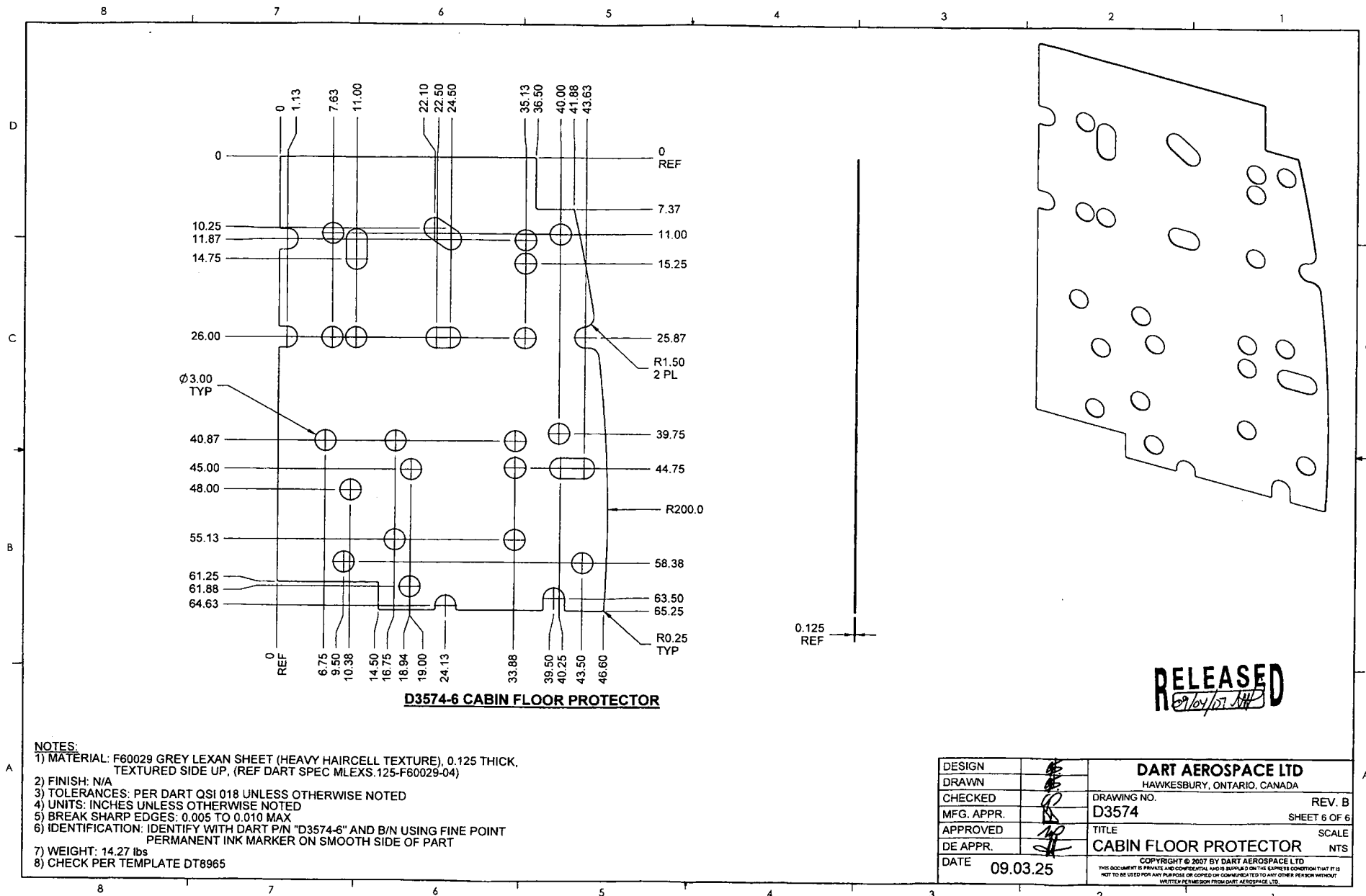
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